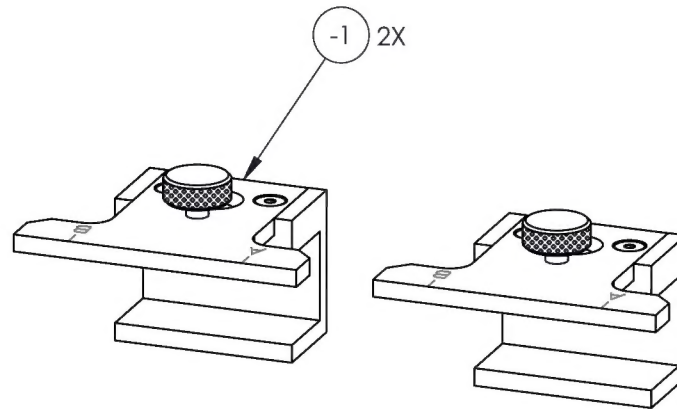


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	9/6/2016	DPD	JAG



NOTE:
REF. AIRBUS T/N: 117-41601W1.

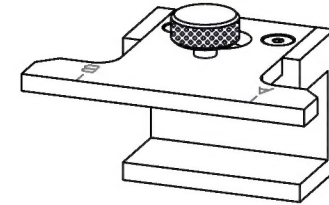
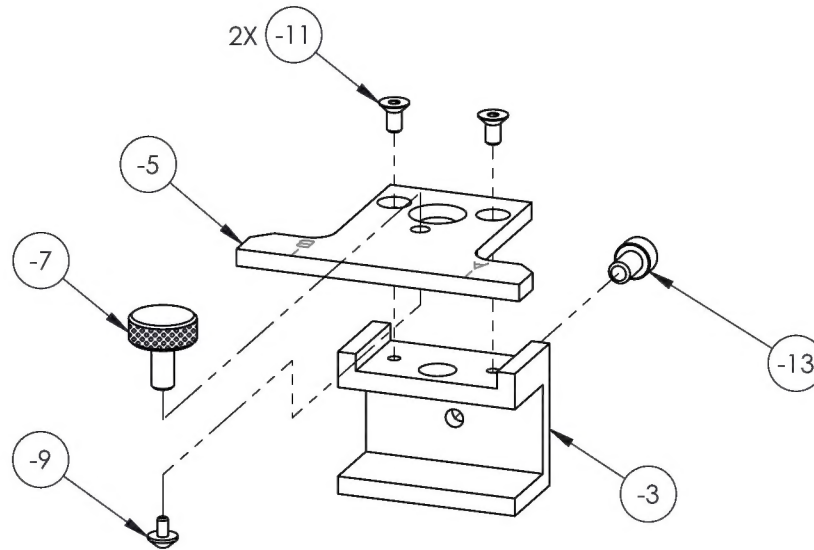


TITLE		POSITIONER	
DWG NO.			
		REV 1	
MAT'L		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125/✓	
HEAT TREAT			
FINISH			
SPEC			
DRAWN BY:		DUERFELDT	
CHECKED:		CLOUGH	
OPPS APPR:		ANDERSON	
QA APPR:		LINDSAY	
APPROVED:		GILBERT	
SCALE		1:2	
DATE		7/21/2016	
SHEET 1 OF 6			

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	2	GAUGE ASSEMBLY			2
	1		-3		GAUGE BLOCK	6061		3
	1		-5		GAUGE PLATE	6061		4
	1		-7		THUMB SCREW	4140/4142		5
	1		-9		ALIGNMENT TIP	4140/4142		6
	2	B/O	-11		FLAT HEAD CAP SCREW	STEEL	M4 X 0.7mm X 8mm (MCMaster-CARR #91263A827)	2
	1	B/O	-13		SOCKET HEAD CAP SCREW	STEEL	M6 X 1mm X 10mm (MCMaster-CARR #91290A316)	2
	ASSY -1							

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

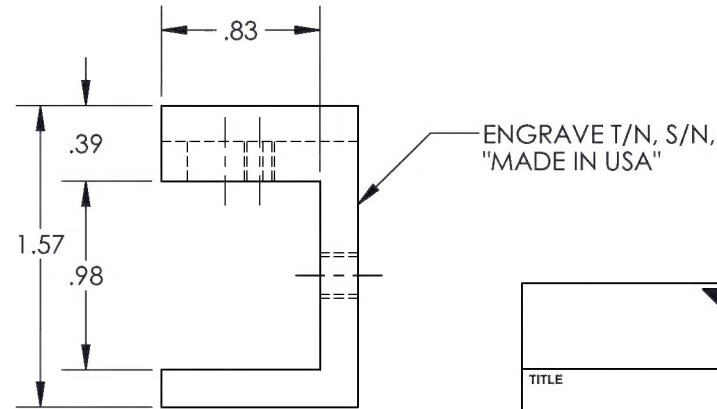
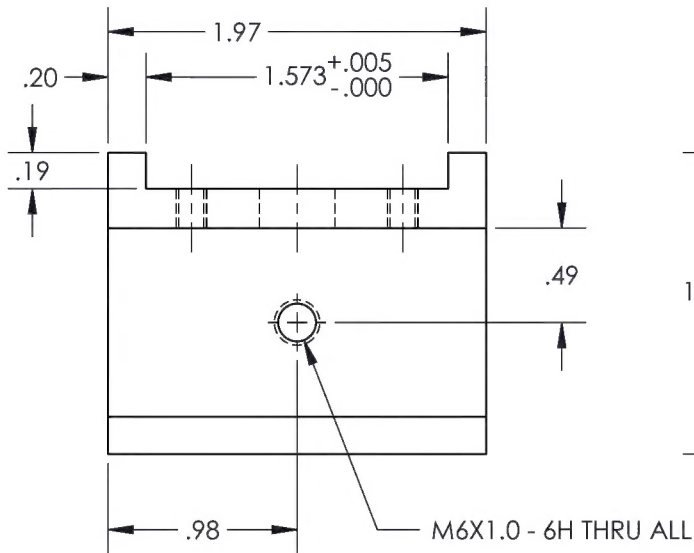
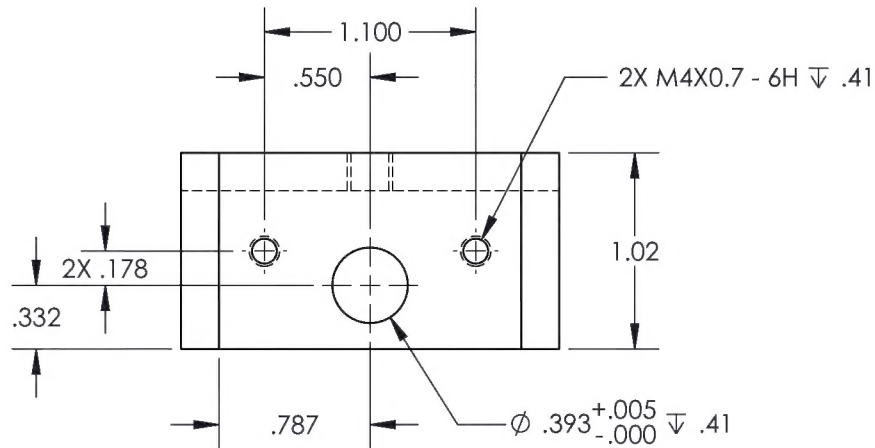
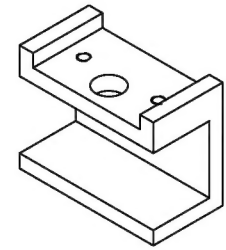


(-1)
GAUGE ASSEMBLY

DART AEROSPACE	
TITLE POSITIONER	
DWG NO. RBE117-41601W1-1	REV 1
MAT'L	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H145
SCALE 1:2	DATE 7/21/2016
	SHEET 2 OF 6

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

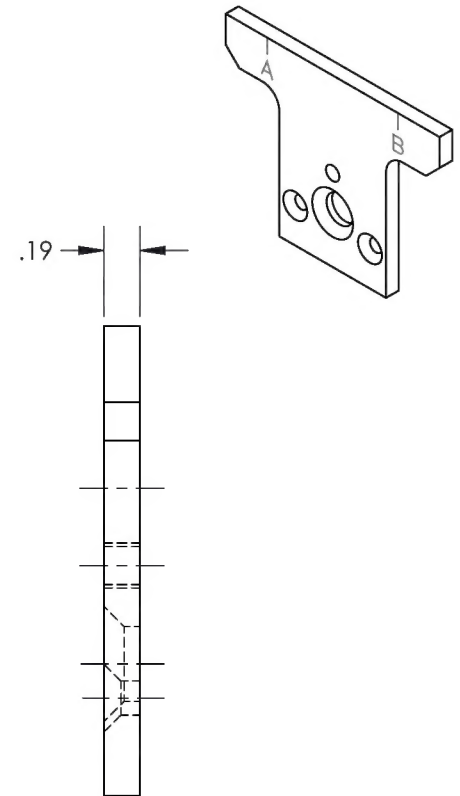
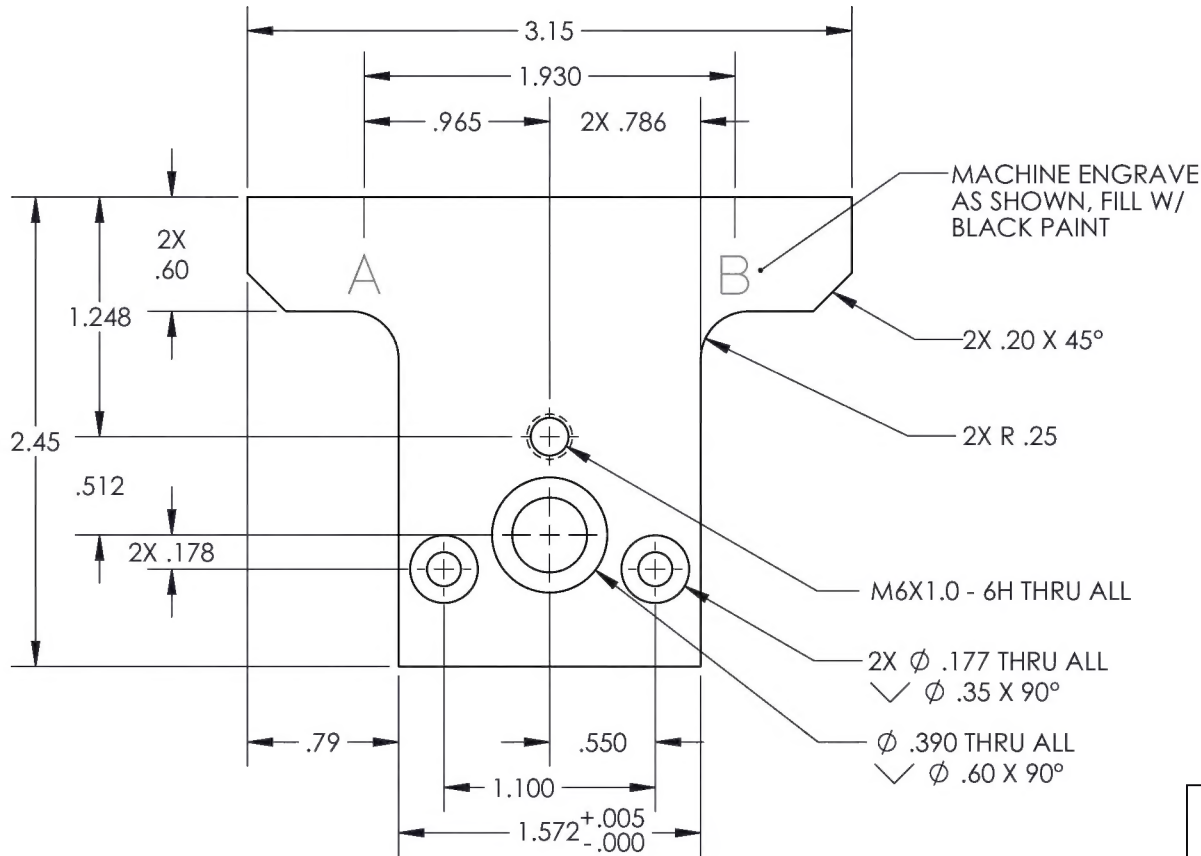


(3)
GAUGE BLOCK

DART AEROSPACE	
TITLE POSITIONER	
DWG NO. RBE117-41601W1-3	REV 1
MAT'L 6061 HEAT TREAT FINISH CLEAR ANODIZE SPEC MIL-A-8625F, TYPE II, CLASS I	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT	USED ON MODEL
CHECKED: CLOUGH	H145
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:1	DATE 7/21/2016
SHEET 3 OF 6	

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED

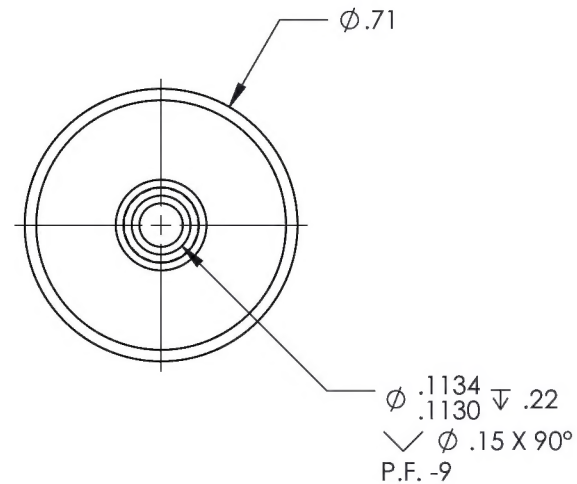
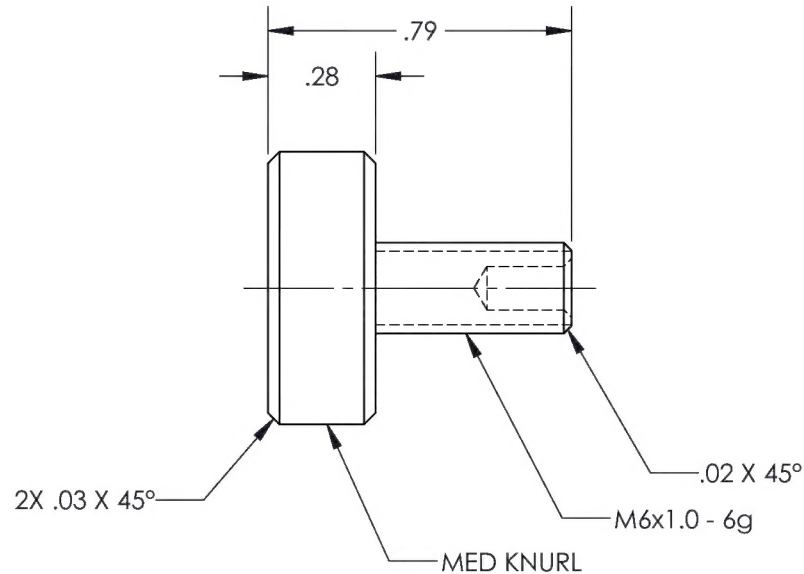
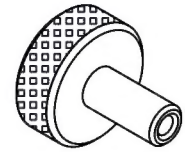


(5)
GAUGE PLATE

DART AEROSPACE	
TITLE POSITIONER	
DWG NO. RBE117-41601W1-5	REV 1
MAT'L 6061	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH CLEAR ANODIZE	.XXX ± .005 FRACTIONS ± 1/8
SPEC MIL-A-8625F, TYPE II, CLASS I	.XX ± .01 ANGLES ± 5°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 7/21/2016	USED ON MODEL
SHEET 4 OF 6	H145

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

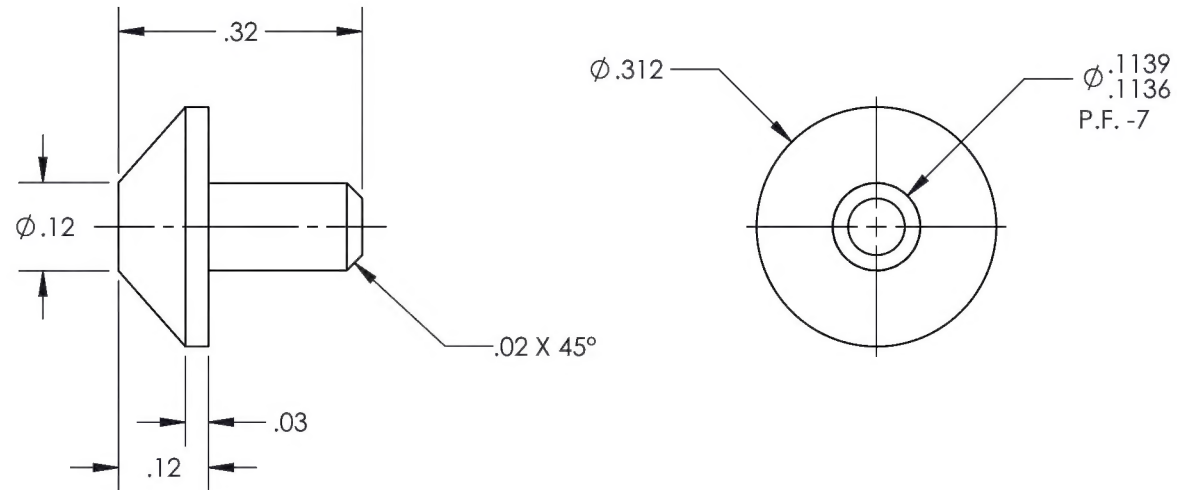


(-7)
THUMB SCREW

DART AEROSPACE	
TITLE POSITIONER	
DWG NO. RBE117-41601W1-7	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 28-32	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± .5°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125°
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 2:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 7/21/2016	USED ON MODEL
SHEET 5 OF 6	H145

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



(-9)

ALIGNMENT TIP

DART AEROSPACE	
TITLE POSITIONER	
DWG NO. RBE117-41601W1-9	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT RC 28-32	DIMENSIONS ARE IN INCHES
TREAT	.XXX \pm .005 FRACTIONS \pm 1/8
FINISH ZINC PLATE	.XX \pm .01 ANGLES \pm 5°
SPEC ASTM B633 TYPE I SC 2	.X \pm .1 SURFACES = 125
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H145
SCALE 4:1	DATE 7/21/2016
	SHEET 6 OF 6